

We claim:

1. A refractory article for use in the casting of molten metal comprising a refractory piece having a first outer surface, an insulating coating having a second outer surface and covering at least a portion of the first outer surface, and a glaze covering at least a portion 5 of the second outer surface.
2. The refractory article of claim 1, wherein the refractory piece comprises a carbon-bonded refractory composition.
3. The refractory article of claim 1, wherein the refractory piece comprises a nozzle.
4. The refractory article of claim 3, wherein the nozzle comprises a thin-slab nozzle.
- 10 5. The refractory article of claim 1, wherein the insulating coating is made from an aqueous suspension comprising 20-80 wt.% ceramic matrix, 5-40 wt.% insulating microspheres, 0.5-15 wt.% one or more binders, 5-20 wt.% of a metal capable of melting under preheat conditions, and up to 25 wt.% water.
6. The refractory article of claim 1, wherein the glaze comprises a composition 15 resistant to oxygen diffusion.
7. A nozzle comprising a carbon-bonded refractory composition having an outer surface at least partially covered by an insulating coating, the insulating coating comprising hollow microspheres and having a second outer surface, and a protective glaze covering at least a portion of the second outer surface.
- 20 8. The nozzle of claim 7, wherein the refractory composition comprises alumina and graphite.
9. A method for making a refractory article comprising:

applying an insulating coating over at least a portion of an outer surface of a refractory piece;

applying a glaze over at least a portion of the dried insulating coating.

10. The method of claim 9 further comprising applying the insulating coating as an aqueous suspension and drying the suspension to form the insulating coating.

5 11. The method of claim 9, further comprising applying the protective glaze as a glaze slip and drying the slip to form a glaze.

12. The method of claim 11, further comprising firing the dried slip to form a protective glaze.

10 13. The method of claim 9, wherein applying insulating coating and glaze includes an application method selected from the group consisting of spraying, dipping, flooding and brushing.